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71 Applicant : **SANDVIK AKTIEBOLAG**
S-811 81 Sandviken 1 (SE)

72 Inventor : **Nyström, Leif**
Rotevägen 1
S-810 28 Järbo (SE)
Inventor : **Lagerholm, Claes**
Sprötgatan 6
S-811 61 Sandviken (SE)
Inventor : **Yakamavich, Anthony F., Jr.**
14 Zinna Drive
Glenwood, New Jersey (US)

74 Representative : **Taquist, Lennart et al**
Sandvik AB Patents & Licences Fack
S-811 81 Sandviken 1 (SE)

54 **Drilling tool and insert therefor.**

57 A cutting (10) insert includes a cutting edge extending obliquely relative to a center line (C) of the insert (10). A chip breaking recess (21) is spaced inwardly from the cutting edge (20) and extends parallel hereto. A drill tool contains three inserts situated along a common diameter. The center insert has a cutting edge radially overlapping the cutting edges of the other two inserts. Each of the cutting edges of the other two inserts extends axially rearwardly and radially outwardly.

Fig. 1

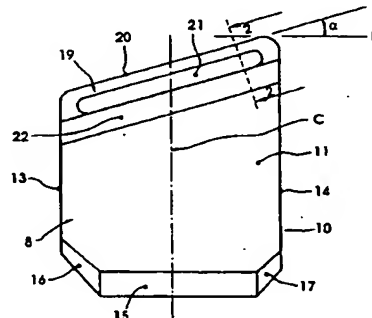
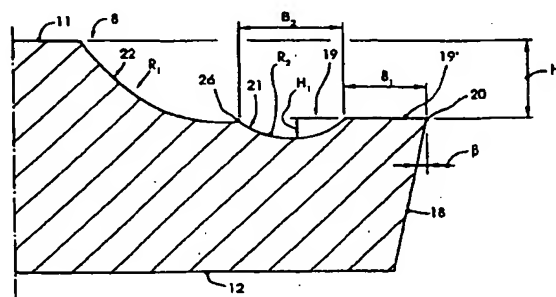


Fig. 2





European Patent
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EUROPEAN SEARCH REPORT

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DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.5)
Y	DE-U-7 224 185 (SANDVIK AB) * claims 1-6; figures 1-4 *	1, 12	B23B27/16
Y	US-A-3 947 937 (K. HERTEL) * claims 1-5; figure 8 *	1, 12 2-11	
A	US-A-4 215 957 (J. E. HOLMA ET AL) * figures 1-9 *	1	
D, A			
			TECHNICAL FIELDS SEARCHED (Int. Cl.5)
			B23B
The present search report has been drawn up for all claims			
Place of search BERLIN		Date of completion of the search 14 OCTOBER 1992	Examiner WUNDERLICH J.
<p>CATEGORY OF CITED DOCUMENTS</p> <p>X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document</p> <p>T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons A : member of the same patent family, corresponding document</p>			

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